Dart Aerospace Ltd. Thursday, 12/20/2007 3:20:05 PM Date Kim Johnston User: **Process Sheet** : CU-DAR001 Dart Helicopters Services **Drawing Name** : BUSHING Customer Job Number : 36480 : 10175 **Estimate Number** : D2570 P.O. Number Part Number **Drawing Number** . D2570 REV B This Issue : N/A Prsht Rev. Project Number : MACHINED PARTS First Issue **Drawing Revision** Previous Run Material : 1/12/2008 **Due Date** Written By Checked & Approved By Re-format; Removed finishing; Material changeK Comment J rev B dwg est F 07.07.06 EC **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: 1.0 M303R0750 303 Round Bar .75" 08/01/06 Comment: Qty.: 0.0810 f(s)/Unit Total : 40.4775 f(s) Material: Ø0.750 AISI 303 SS Rod (M303R0.750) M106633 20 HARDINGE HARDINGE CNC LATHE SMALL Comment: HARDINGE CNC LATHE SMALL Machine as per folio FA198 Comment: INSPECT PARTS AS THEY COME OFF MACHINE QC8 SECOND CHECK Comment: SECOND CHECK 5.0 **PACKAGING 1** PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1

Identify and Stock

Each

Dart Aerospace Ltd

W/O:		WO	RK ORDER CHANGES					
DATE	STEP	PROCEDURE CHAN	GE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #: Fault Categ	ory:NCI	R: Yes	NO DQ	A: <u>D</u>	Date:	28101108
				QA:	N/C Close	d:	_ Date: _	

NCR:			WORK ORD	ER NON-CONFORMANO	E (NCR)			
		Description of NC		Corrective Action Section B	Varification		Ammanal	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date:

Thursday, 12/20/2007 3:20:05 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 36480

Part Number: D2570

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



650

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2008/1/8

Dart Aerospace Ltd

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W/O:			WC	ORK ORDER CHANG	GES				
DATE	STEP	PRO	DCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Ye	No DC	A:	Date:	
					QA:	N/C Close	ed:	Date: _	
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		Description of NC	Corrective Action Section B		tion B	Vorifi	cation	A = = = = = 1	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat	Sec.	Verification Approva Section C Chief Eng	Approval Chief Eng	QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36480
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

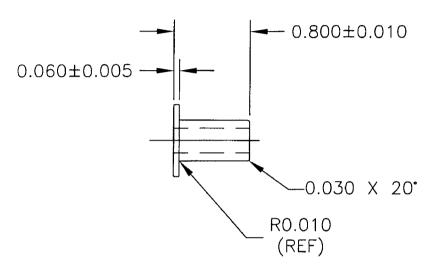
	Х	First Arti	cle	Prot	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	,80/"				
0.060	+/-0.005	1062"				
R0.010	+0.010/-0.000	BO, 010"				
Ø0.425	+0.000/-0.002	0,424				
Ø0.257	+0.005/-0.000	0,257"				
Ø0.750	+/-0.010	\$,745"				
0.030 x 20°	+/-0.010	0,028×20°				
						

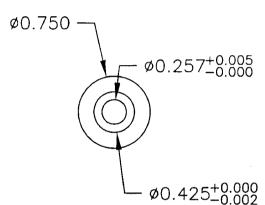
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 08/0//04	Date: 08/01/04	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue	KJ/RF	
В	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
С	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM	E



DESIG	N <i>PH</i>	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECH	KED 1/	APPROVED J	DRAWING NO. REV.	. В
	世	91	D2570 SHEET 1 OF	F 1
DATE			TITLE SC/	ALE
07.0	04.17		BUSHING	1:1
Α		96.09.16	NEW ISSUE	
В		07.04.17	UPDATE NOTES	





D2570 BUSHING

D2570 BUSHING

1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)

2) FINISH: NONE

- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER NO. 3648

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